

Date: Tuesday, 23/12/2008 12:53:29 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE, OUTBOARD, LH, 206
Job Number : 44282	
Estimate Number : 10818	
P.O. Number :	Part Number : D26651
This Issue : 23/12/2008 S.O. No. :	Drawing Number : D2665 REV.D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 43851	Material :
Written By :	Due Date : 09/01/2009 Qty: 6 Um: Each
Checked & Approved By :	
Comment : Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC	
Est Rev:D As per Rev D 07-03-19 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	Saddle Billet, 7075
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
 7075-T7351 2X6.25X7.875
 Cut Size 2.0" x 6.25" x 7.88"
 Grain Along Long 7.88 Length

Batch no: B 34873

J.F. 08/12/28

⑥

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program batch number.
 1- Inspect part number and batch number are programmed correctly.
 2- Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet
 3- Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet
 4- Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet
 5- Deburr

J.F. 08/12/28

⑥

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine Keyway and inspect per attached dimension sheet

J.F. 08/12/28

⑥

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/12/28

⑥

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 23/12/2008 12:53:29 PM
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Part Number: D26651

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SP 08/12/29 (6)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L 08/12/30

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:00
320°F
11:30

M-L 08/12/30

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

8/12/30

SP (6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

436

8/12/30

6X
SP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AD 09/01/05 (6)

Job Completion



CMF 08-12-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

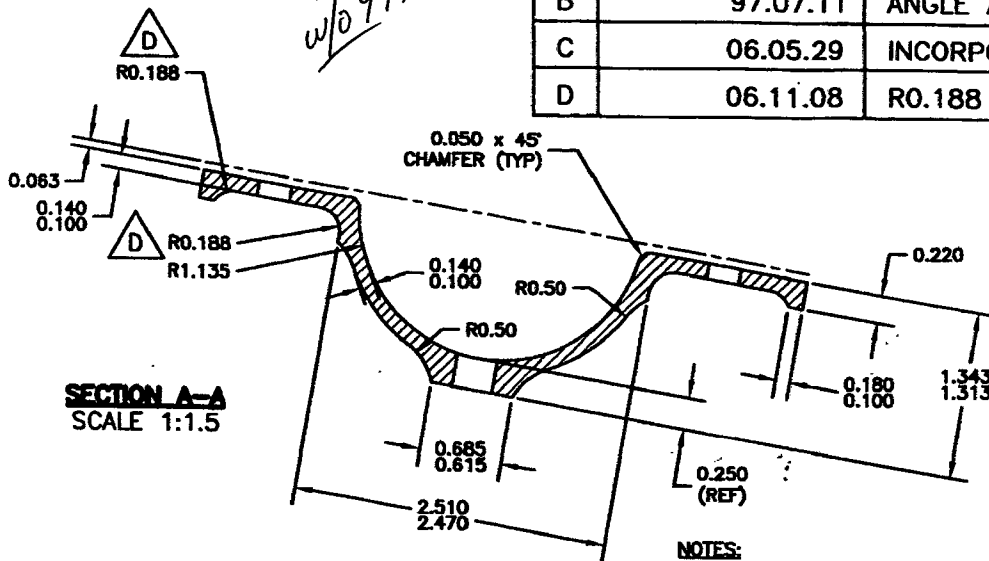
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #	DRAWING NO. D2665	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE FWD OUTSIDE HIGH		SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	

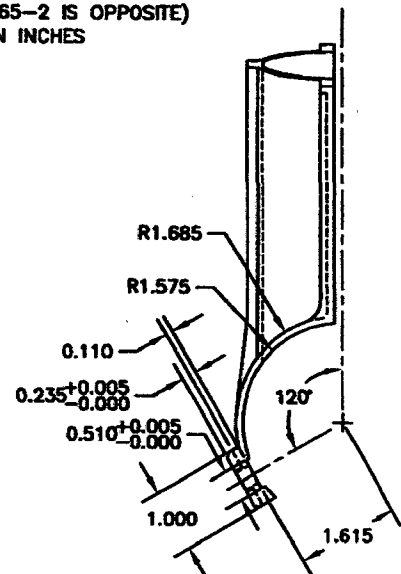
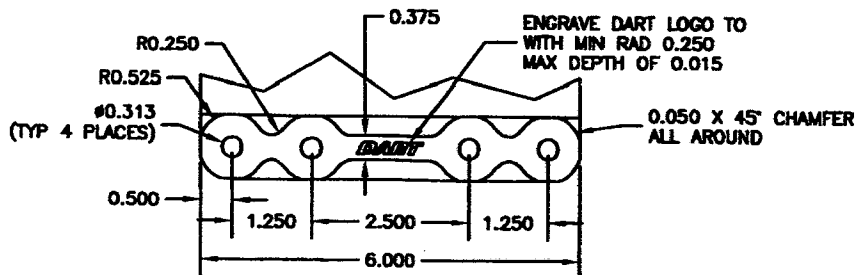
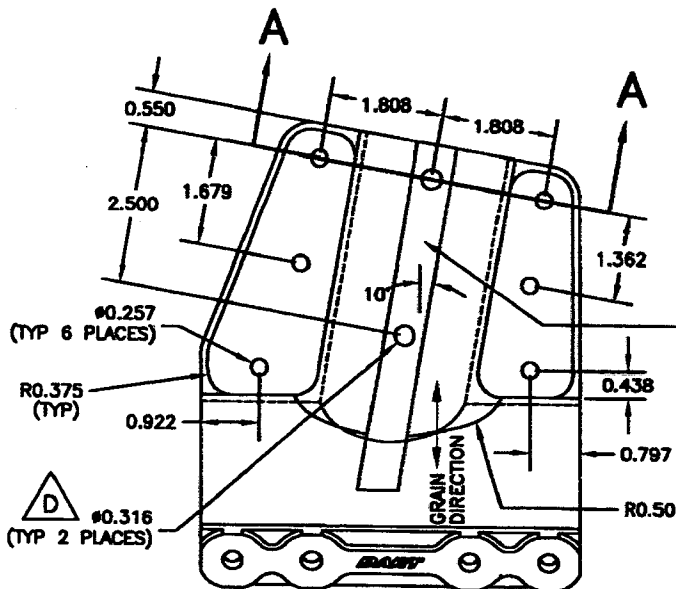


RELEASED

07.02.12 #

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

**D2665-1 SADDLE FWD OUTSIDE HIGH****Copyright © 1997 by DART AEROSPACE USA, INC.**

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DART AEROSPACE LTD	Work Order: 44282
Description: 206 Saddle, Outboard, Left side	Part Number: D2665-1
Inspection Dwg: D2665 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.109"	.109"	.109"	.109"		
B	0.100	0.140		.130"	.130"	.130"	.131"		
C	1.125	1.145		1.136"	1.136"	1.136"	1.136"		
D	0.615	0.685		.671"	.671"	.671"	.671"		
E	0.240	0.260		.245"	.251"	.250"	.250"		
F	1.313	1.343		1.326"	1.326"	1.326"	1.326"		
G	0.210	0.230		.220"	.220"	.220"	.221"		
H	0.100	0.180		.135"	.135"	.135"	.135"		
I	2.470	2.510		2.494"	2.494"	2.494"	2.494"		
J	1.565	1.585		1.574"	1.575"	1.574"	1.575"		
K	0.235	0.240							
L	0.100	0.120		.110"	.110"	.110"	.110"		
M	0.990	1.010		1.006"	1.006"	1.006"	1.006"		
N	0.510	0.515							
O	5.990	6.010		5.998"	5.998"	5.998"	5.998"		
P	1.245	1.255		1.251"	1.251"	1.251"	1.251"		
Q	2.495	2.505		2.500"	2.500"	2.500"	2.500"		
R	0.313	0.318		Ø.314"	Ø.314"	Ø.314"	Ø.314"		
S	0.315	0.322		Ø.316"	Ø.316"	Ø.316"	Ø.316"		
T	2.495	2.505		2.500"	2.500"	2.500"	2.500"		
U	1.357	1.367		1.364"	1.363"	1.364"	1.364"		
V	0.787	0.807		.799"	.799"	.797"	.798"		
W	0.540	0.560		.550"	.550"	.551"	.550"		
X	1.674	1.684		1.680"	1.680"	1.682"	1.682"		
Y	0.257	0.262		Ø.259"	Ø.259"	Ø.259"	Ø.259"		
Z	0.912	0.932		.923"	.925"	.924"	.922"		
AA	0.490	0.510		.501"	.501"	.505"	.501"		
AB	0.178	0.198		R.188"	R.188"	R.188"	R.188"		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: J.F.	Audited by:
Date: 08/12/28	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

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